

Work Order ID 79645

January-31-12 7:50:46 AM

79645

Page 1

Item ID: D205-634-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 1/31/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580-047

(DEO) revE

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG002

110

0.00

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Inspect mat'l D2500-1-190 for damage
2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
3-Drill pilot holes using drill jig DT 8149 and open holes to finish size
4-Acid etch and Alodine tube per QSI 005 4.1
5- Install web as per dwg using sikaflex
A/R Sikaflex Batch #: M119999

>

①

⊗

CF 12-2-2

①

⊗

MB/DA 12/2/13

→ ①

CF

12-2-3

12/02/03

B79645R+1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 79645

79645

Page 2

January-31-12 7:50:46 AM

Item ID: D205-634-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | | 0.00 | | | | | | | |
| *120* | BENDING MACHINE - SKIDTUBES | | | | | | | | |
| CNC Bend 1 | Memo | 0.00 | | | | | | | |
| CNC Delta 100 Bender | 1-Bend as per program D2580.C on CNC Bender and Folio FT 16 2-Cut tubes as per Dwg. D2580 3-Scribe batch# in aft end of tube | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Deburr ends after cutting. Remove alodine from around holes N/A 2-Drill extra fwd hole as per DEO 9183 using drill jig DT8461 3-Drill extra middle hole as per DEO 9183 using drill jig DT8462 4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN OPEN Holes | | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

> DP 12-2-6

DP 12-2-6
> DP 12-2-7
BB 12/02/07

1 Ø BE 12/02/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 79645

79645

Page 3

January-31-12 7:50:46 AM

Item ID: D205-634-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Skidtubes | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Prepare tube for welding D2576-3 Step Remove alodine as required. 2-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4- Grind cap | | | | | | | | |
| 160 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12-02-09

12-2-9

8.2.10/09

8.2.10/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 79645

January-31-12 7:50:46 AM

79645

Page 4

Item ID: D205-634-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180 Pressure Wash per QSI005 4.3 0.00

180

HandFinish

Memo

0.00

Hand Finishing

And realodine tube as per QSI 005

1 ~~0~~ CF 12-2-9

190 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1-20 0.00
3200 F
1-30

1X ~~0~~ M-12/02/09

200 QC3- Inspect Part Finish 0.00

200

QC

Memo

0.00

Quality Control

1 ~~0~~ M-12/02/09

m11a480

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

January-31-12 7:50:45 AM

Work Order ID: 79645

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

D4406-041 Manufactured No
Fwd Wearplate Assembly

Location

FP002

74147

D4406-043 Manufactured No
Aft Wearplate Assembly

Location

FP001

74149

MS21042-4 Purchased No
USE MS21042L4 *

Location

ST299

100743

119124

5389

5461

6844

7690

8182

9063

9229

D2576-3 Manufactured No
Step (maching detail)

Location

LG

70883

74136

January-31-12 7:50:45 AM

Sh

Picklist Print

January-31-12 7:50:45 AM

Work Order ID: 79645

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Comments: IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER
ECN11-684 DD VERF:EC

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

AN4-45A Purchased No
Bolt

Location

ST350A

Loc Qty

96

Loc Code

96

118926

D2500-1-190 Manufactured No
Ext'n - I' Beam Tube 4"

Location

HALL

Loc Qty

60

Loc Code

60

74777

D2570 Manufactured No
Bushing

Location

ST011

Loc Qty

607

Loc Code

41

72960

78585

78586

78587

166

200

200

D2596 Manufactured No
Web, 205 Skidtube

Location

ST011

Loc Qty

110

Loc Code

110

79766

D4202-1 Manufactured No
Spacer

Location

LG

Loc Qty

150

Loc Code

446

77723

77729

123

LG002

323

78806

514

514

Page 1

3

8 8
xl 1202109

x 8

1 1

① CF 12-2-2
16 xl 1202109

x 11
v 5

1 1 12-2-3

20 20

① 12-02-08
① 12-02-08

Dart Aerospace Ltd

| | | |
|------|------|------------------|
| W/O: | | WC |
| DATE | STEP | PROCEDURE CHANGE |
| | | |
| | | |

Part No: _____ PAR #: _____ Fault Category: _____
Resolution: _____ Disposition: _____

| | | | |
|------|------|--------------------------------|-----------|
| NCR: | | WORK ORDER | |
| DATE | STEP | Description of NC Section A | Initial |
| | | | Chief Eng |
| | | | |
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NOTE: Date & initial all entries
H:\FORMS\Quality Assurance\approved QANCRWO RevE

Dart Aerospace Ltd

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| W/O: | | WORK ORDER CHANGES | | | | | |
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries
H:\FORMS\Quality Assurance\approved QANCRWO RevE

Picklist Print

January-31-12 7:50:45 AM

Page 3

Work Order ID: 79645

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 210 Each 80.0000

Cap

1 del 12/03/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 80 | |
| 65519 | 2 | |
| 73347 | 30 | |
| 75074 | 48 | |

AN3-5A Purchased No 210 Each 1,254.0000

Bolt

2 del 2/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST350 | 1254 | |
| 115371 | 46 | |
| 117423 | 210 | |
| 118626 | 298 | |
| 119355 | 200 | |
| 120187 | 500 | |

AN960JD10L NAS1149D0332J * Purchased No 210 Each 0.0000

Washer

2 11/19/042 x2 del 2/02/09

D2594-3 Manufactured No 210 Each 296.0000

O-Ring, 205 Skidtube

8 del 2/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 296 | |
| 65518 | 41 | |
| 73490 | 255 | |

D2594-1 Manufactured No 210 Each 562.0000

Plug, 205 Skidtube

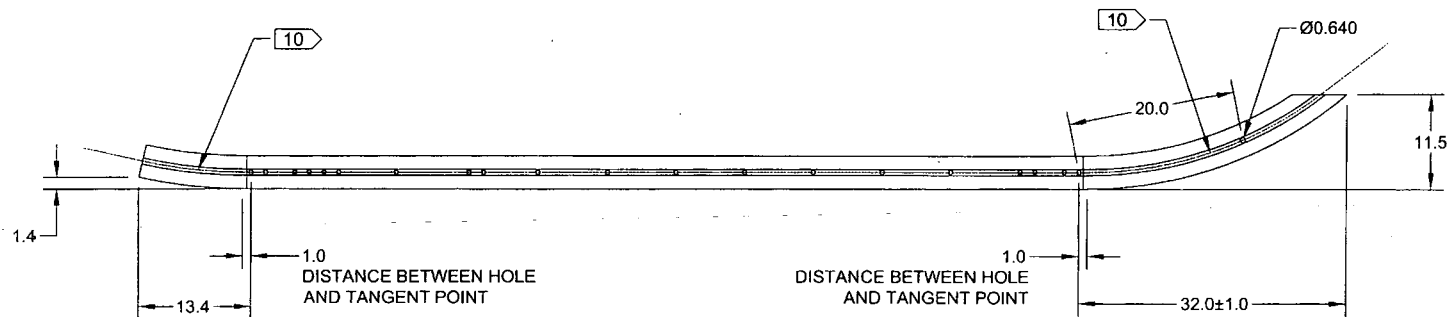
8 del 2/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 562 | |
| 73401 | 30 | |
| 74442 | 34 | |
| 74869 | 184 | |
| 76075 | 64 | |
| 77035 | 250 | |

January-31-12 7:50:45 AM

Shop Packet Print

Page 3

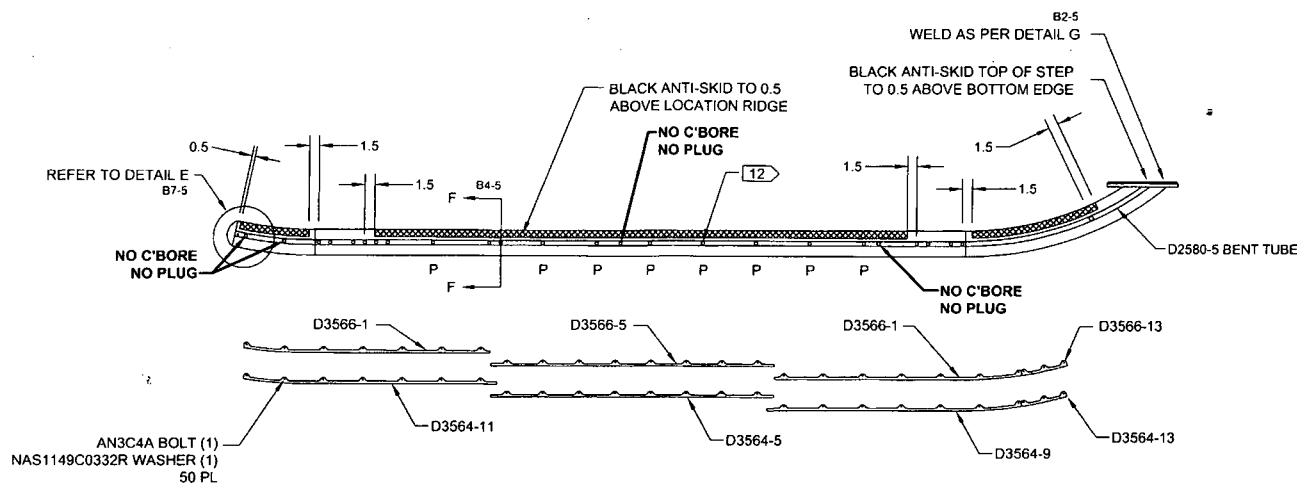


D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

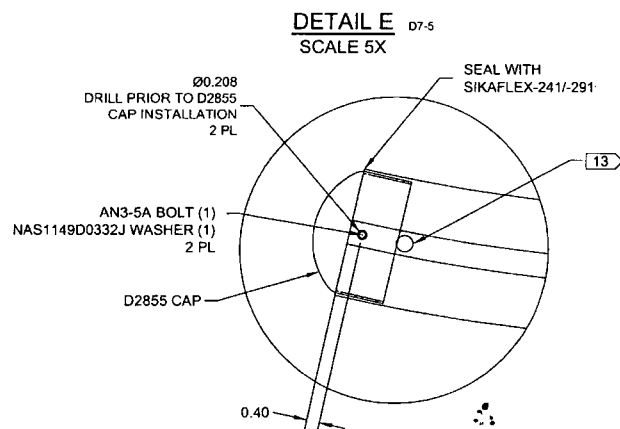
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2011-08-28
JW

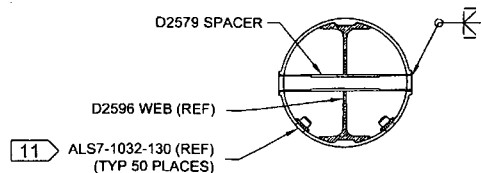
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|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 10 | D2580 | SHEET 3 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | 205 SKIDTUBE ASSEMBLY | NTS |
| DATE | 11.06.21 | COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



D2580-045 ASSEMBLY DETAIL

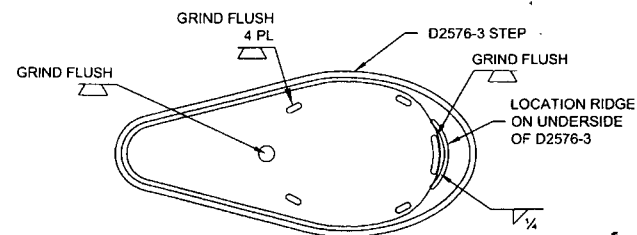


SECTION F-F SCALE 5X



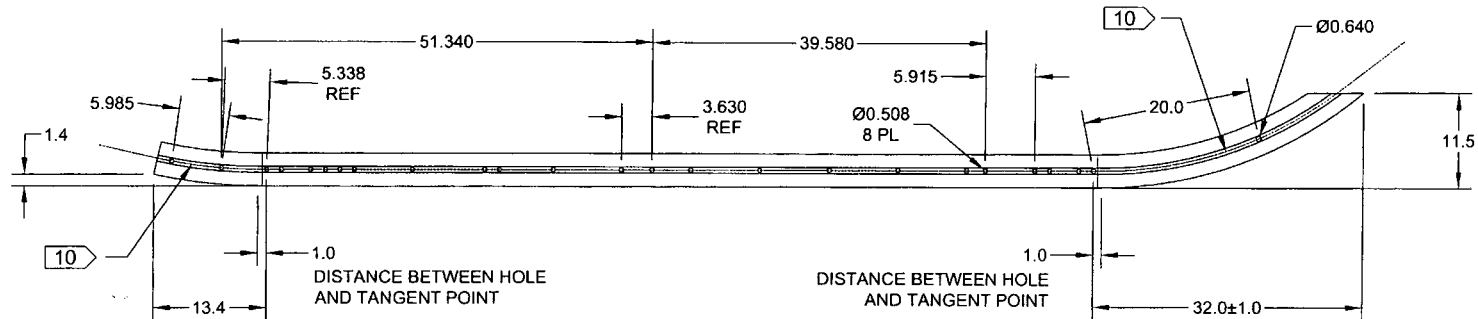
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (24 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL G SCALE 5X



**DEO ATTACHED
RELEASED**
2011-08-29

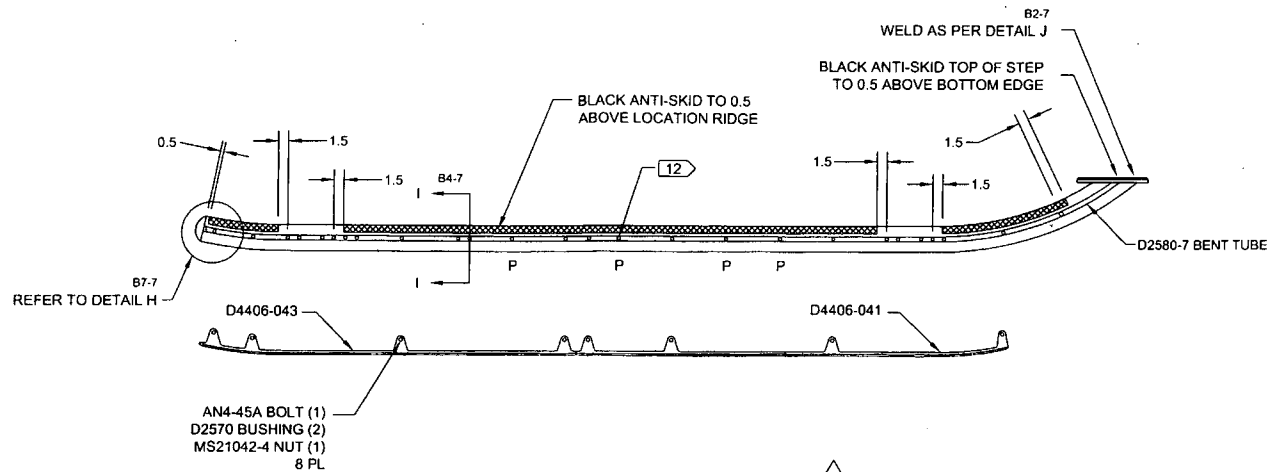
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|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 10 | D2580 | SHEET 4 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | 205 SKIDTUBE ASSEMBLY | NTS |
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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

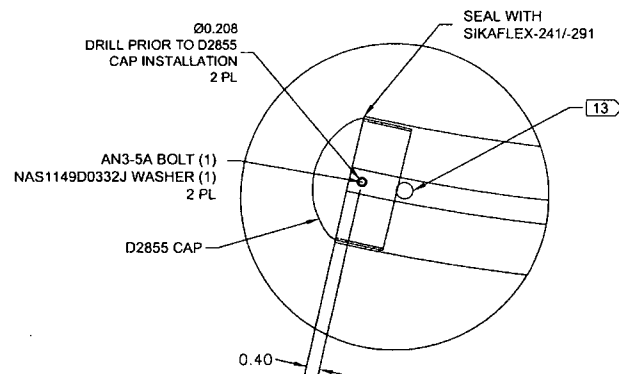
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2011-08-29
ND

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|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ND | DRAWING NO. | REV. E |
| MFG. APPR. | ND | D2580 | SHEET 5 OF 8 |
| APPROVED | ND | TITLE | SCALE |
| DE APPR. | ND | 205 SKIDTUBE ASSEMBLY | NTS |
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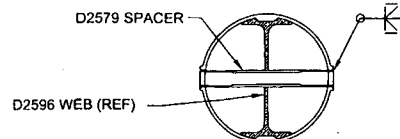


D2580-047 ASSEMBLY DETAIL E

DETAIL H C6-7
SCALE 5X

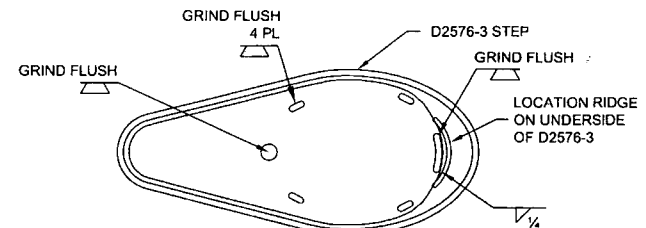


SECTION I-I D5-7
SCALE 5X



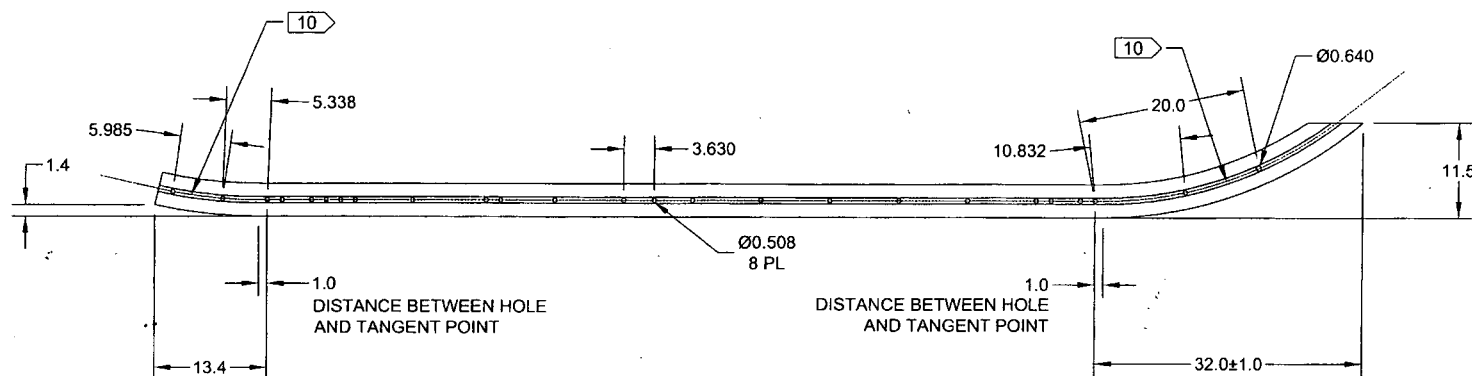
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (25 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL J D3-7
SCALE 5X



| | | | |
|--|---------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. E |
| MFG. APPR. | RF | D2580 | SHEET 6 OF 8 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | 205 SKIDTUBE ASSEMBLY | NTS |
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RELEASED
2011-08-29

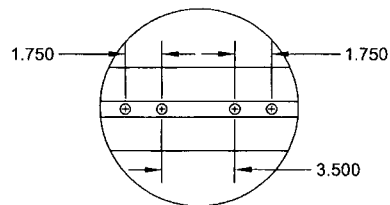
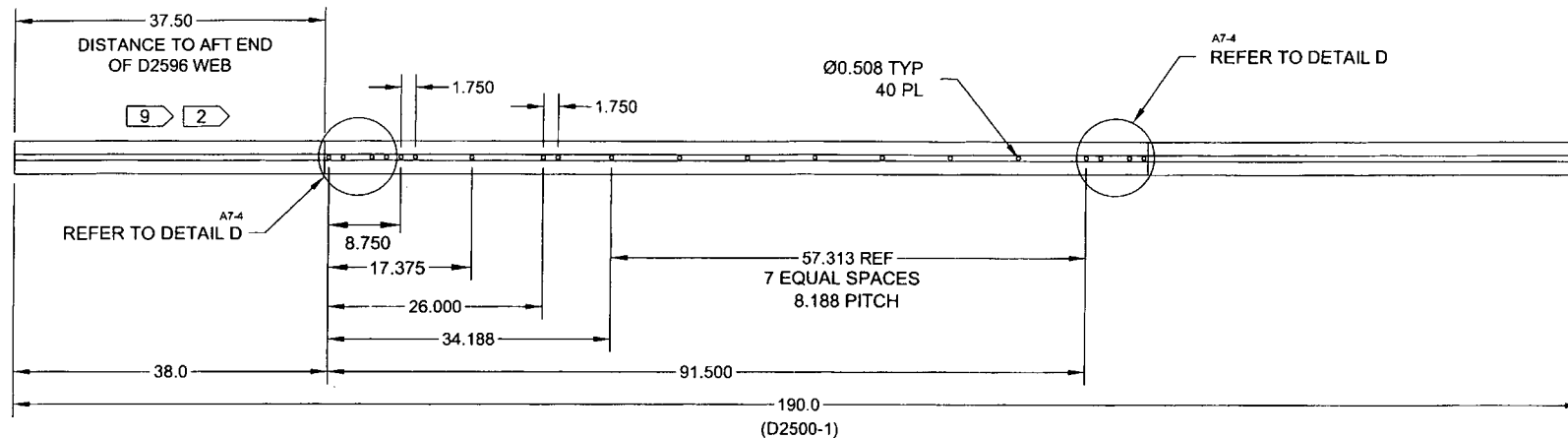


D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)



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RELEASED
2011-08-29

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| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. E |
| MFG. APPR. | RF | D2580 | SHEET 7 OF 8 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | 205 SKIDTUBE ASSEMBLY | NTS |
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DETAIL D 03-4
SCALE 5X C7-4

D2580-101 TUBE

DEO ATTACHED
RELEASED
R 2011-08-29

| | | | |
|--|---------------|--|--------------|
| DESIGN | AP | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | DRAWING NO. | REV. E |
| MFG. APPR. | AP | D2580 | SHEET 8 OF 8 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | 205 SKIDTUBE ASSEMBLY | NTS |
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| | | | | | | |
|----------------------|--------------------------------|----------------------|---|-------------------------|---------------------------|--------------|
| DRAWING NO. D2580 | TITLE 205 SKIDTUBE ASSEMBLY | REV. E | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D2580-E-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>up</i> | CHECKED <i>ASS</i> | MFG. APPR. <i>EC</i> | APPROVED <i>#</i> | DE APPR. <i>#</i> | | |
| DATE 11.12.13 | DATE 11.12.13 | DATE 11.12.13 | DATE 11.12.13 | DATE 11.12.13 | | |

PURPOSE:

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

| QTY | QTY | QTY | PART NUMBER | DESCRIPTION |
|------|------|------|-------------|-------------------|
| -041 | -045 | -047 | | |
| 20 | 24 | 25 | D2579 | CROSS BOLT SPACER |

IS

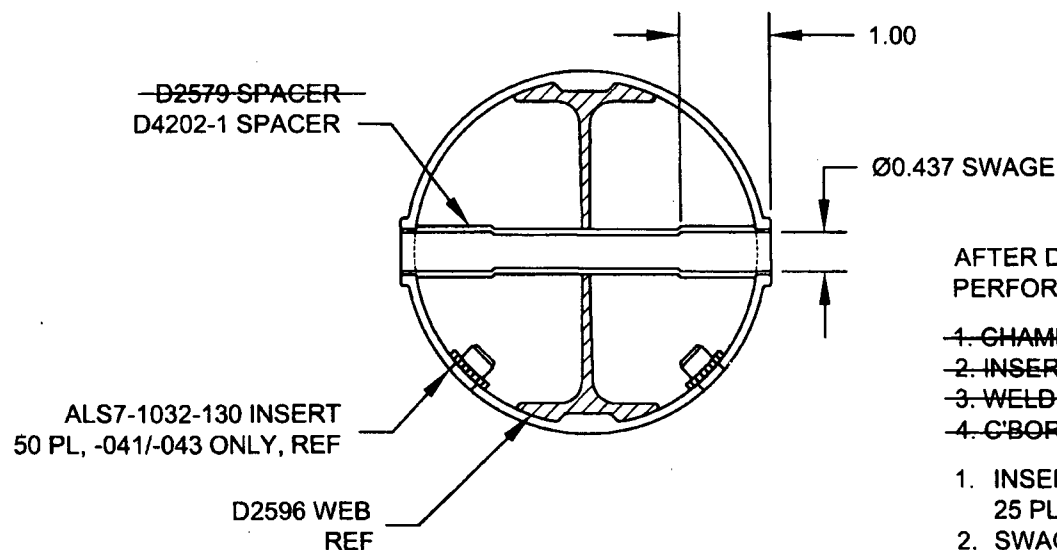
| | | | | |
|----|----|----|---------|-------------------|
| | 4 | | * D2579 | CROSS BOLT SPACER |
| 20 | 20 | 25 | D4202-1 | SPACER |

SECTION B-B, SECTION F-F, & SECTION I-I ARE AMENDED AS FOLLOWS
FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:

*** FOR -045 SKIDTUBE ONLY:**

WELD 4X D2579 SPACERS PER DWG
IN LOCATIONS MARKED "NO C'BORE".
REF SHEET 4 OF DWG.

RELEASED
2011-12-14 *[Signature]*



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- ~~1. CHAMFER HOLE 0.060 X 45°~~
- ~~2. INSERT D2579 SPACER (20 PLACES)~~
- ~~3. WELD INTO PLACE AND GRIND FLUSH~~
- ~~4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP~~

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 20 PL (-045) OR 25 PL (-047)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B, F-F, I-I
NOT TO SCALE

1113

1-1

CO. 100

1

1113

1113

1-1-1